

6061 750



Dart Aerospace Ltd.
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Canada

Tel (613) 632-5200
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D3490-3

Job Sheet 200807



Part No: D3490-3

Job Qty: 40 pcs

Part Name: Cross Bolt Spacer



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/28/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP Rev:A New Issue 06-03-03 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Run Hrs Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	40 pcs		10/28/19	0.50 2.00	Hardinge - 1		19/10/13 / 60.0
120	QC 8	40 pcs		10/28/19	0.00 0.00	QC 8 - 12		
						QC 8 - 14		
						QC 8 - 17		
						QC 8 - 20		
						QC 8 - 25		
						QC 8 - 3		
						QC 8 - 32		3-C-14-10-15
						QC 8 - 33		
						QC 8 - 35		
						QC 8 - 39		
						QC 8 - 4		
						QC 8 - 44		
						QC 8 - 45		
						QC 8 - 49		
						QC 8 - 58		
						QC 8 - 8		
						QC 8 - 9		
						QC 8 - 68		
						QC 8 - 67		
						QC 8 - 1 (A)		
						QC 8 - 47		
						QC 8 - 40		
						QC 8 - 52		
						QC 8 - 23		
						QC 8 - 57		
						QC 8 - 76		
124	Handfinish - 4-1-Assembly-B4B	40 pcs		10/28/19	0.00 0.67	Handfinish - 4 - 1 - B4B		
						Handfinish - 4 - 10 - B4B		



Container No: S222157



Part: D3490-3

Job No: 200807

Serial No/Batch: S222157

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/13/19

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						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	SE
						Handfinish - 4 - 5 - B4B	
						Handfinish - 4 - 6 - B4B	
						Handfinish - 4 - 7 - B4B	
						Handfinish - 4 - 8 - B4B	
						Handfinish - 4 - 9 - B4B	
130	Packaging 3-1 - Stock - B4B	40	10/28/19	0.00	0.00	Packaging 3 - 1 - B4B	
	pcs					Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	
						Packaging 3 - 5 - B4B	
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	

				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	BF
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	40 pcs	10/28/19	0.00 0.00	QC 21 - SA - 21	0.45
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9.39
Part Op 100 - Hardinge - 1-TURN AS PER FOLIO FA629 & DWG D3490 Descriptions: 120 - QC8- Inspect parts - second check) 124 - Assemble as per dwg - CLEAN CROSSBOLT SPACER WITH ALUMINUM CLEANER 130 - Identify as per dwg & Stock Location: <u>LG001</u> ***STOCK IN SKIDTUBE CELL*** 140 - QC21- Final Inspection - Work Order Release					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M6061T6R0.750	6061-T6 Round Bar .750"	10.6400 ft (.266 ea)	100-Hardinge - 1	S 216336	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Hardinge - 1	M6061T6R0.750	11	8	0	
Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Crossbolt Spacer	3.085inches + 0.030 - 0.000	3.115 3.085		
2	Crossbolt Spacer	0.080inches ± 0.010	0.090 0.070		
3	Crossbolt Spacer	0.050inches ± 0.010	0.060 0.040		
4	Crossbolt Spacer	45.0Degrees ± 0.0	0.0 0.0		

Plex 9/18/19 8:54 AM Dart.lajeunesse.marie



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Cross tube ☐ Small Fab ☐ Finishing ☐ Skid-tube ☐ Machining ☐ Large Fab ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐	
Date: _____	Sequence #: _____	QTY Affected: _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY			
		Pressure/Forced Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Other/Details: _____		Contamination Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐	
		Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐		Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐	
		Completed By _____		QC / QA Coordinator _____	
Lead hand / Supervisor _____					